

Work Order ID 63196

Monday, October 25, 2010 10:52:53 AM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 10/25/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PH

Date:

10/10/25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: *111585*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *111585*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAD 10-10-05

Cpl 10-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

PE10-10/11/24
42
2012

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE
PE 10-11-28
2

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
10-11-29
2

W/O:		WORK ORDER CHANGES					
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Page 3

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/25 JF
MF
10-11-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, October 25, 2010 10:52:57 AM

Page 1

Work Order ID: 63196

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

40.0000

1



Bushing

Location

Loc Qty

Loc Code

ST084

21

56942

21

WA

19

54072

9

61379

10



10-11-23

B63875 → (2)

M304TS0.750W.065

Purchased

No

100

f

468.6990

1.0317

2.172



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

315.30255

112398

0

114482

0.0002

115494

32.8937

115593

282.40865

WA

153.396485

114520

0.527385

115274

16.027

115901

136.8421



SAD 10-11-05

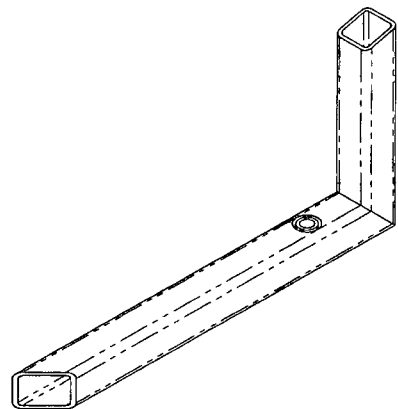
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

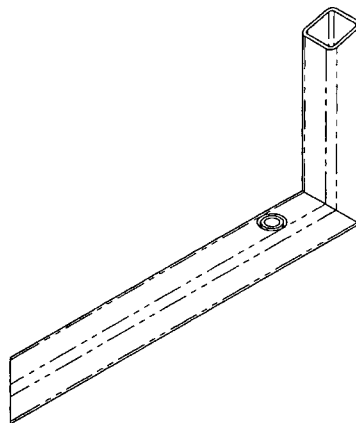
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6399

10.025

RELEASED
08/11/08

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

A		NEW ISSUE		M8		08.10.08	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 3	
DRAWN							
CHECKED	<i>[Signature]</i>	DRAWING NO.		D3838		SCALE	
MFG. APPR.	<i>[Signature]</i>	TITLE		RIB ASSY (BASKET LID)		NTS	
APPROVED	<i>[Signature]</i>	DATE		08.10.08		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

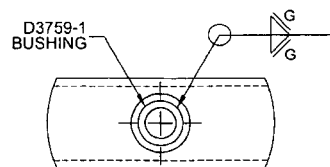
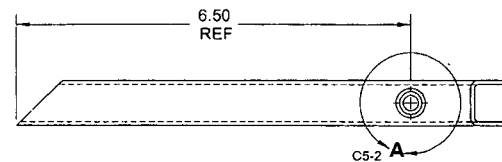
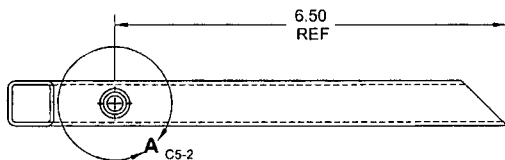
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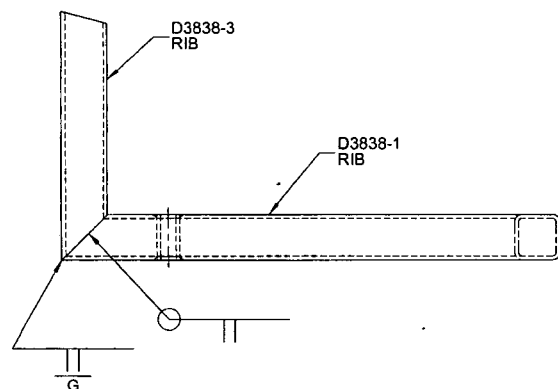
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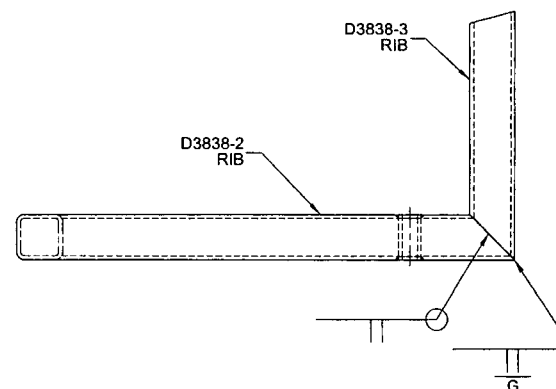
NOTE: Date & initial all entries



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, LH)

26063196

RELEASED
08/10/08

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>SS</i>	D3838	SHEET 2 OF 3
APPROVED	<i>SS</i>	TITLE	SCALE
DE APPR.	<i>SS</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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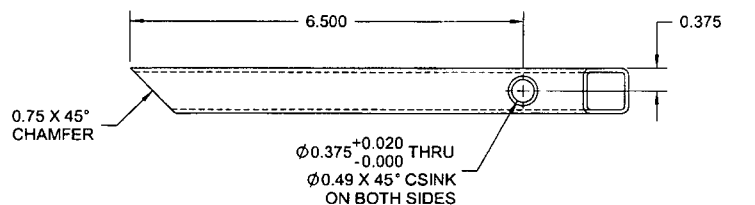
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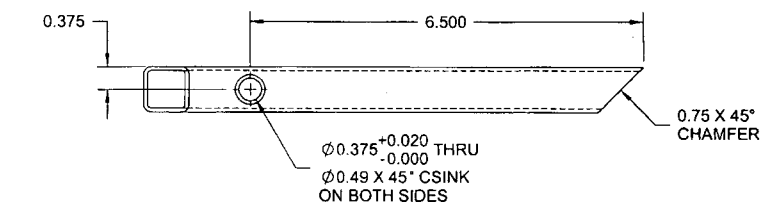
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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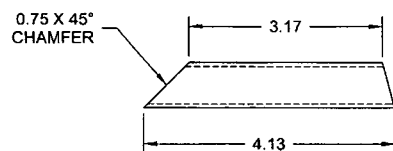


D3838-1 RIB

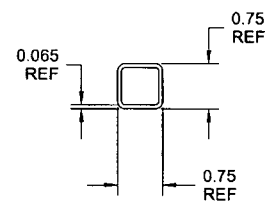


D3838-2 RIB

C



D3838-3 RIB



**TYPICAL SECTION
VIEW**

u60346

RELEASED

A

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3838	REV. A SHEET 3 OF 3
CHECKED	<i>[Signature]</i>	TITLE RIB ASSY (BASKET LID)	SCALE NTS
MFG. APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
APPROVED	<i>[Signature]</i>	DATE 08.10.08	
DE APPR.	<i>[Signature]</i>		

8 7 6 5 4 3 2 1

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